

ABSTRACT OF THE DISCLOSURE

5 The present invention discloses a hydroforming process for metal parts that uses liquid-film and solid-film lubricants. The lubricants used in the invention are particularly useful for die-side lubrication. The process includes a step in which a ductile metal part is over-coated with either the liquid-film or solid-film lubricant. The liquid lubricants preferably include an oil and a optionally a
10 surfactant. The solid lubricants preferably include a hard wax and optionally a surfactant.